

# Work Order ID 56702

March 4, 2010 12:43:29 PM



Page 1

Item ID: D3694-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Plate

Start Date: 3/05/10 Start Qty: 5.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3694

Rev C

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank 7.150" long

0.00

0.00

*H.A 10/03/10*

*5 0*

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Mill as per Folio FA731 Rev: *C* & Dwg D3694 Rev: *C* □ 2-Tap 10-32 heli-coil holes Manually □ 2-Deburr per dwg D3694

0.00

0.00

*H.A 10/03/10*

*5 0*

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

*H.A 10/03/10*

*5 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3694-1 PAR #: \_\_\_\_\_ Fault Category: <sup>① Prod-Eng-Covered</sup> ② Unmachined parts NCR: Yes No DQA: ✓ Date: 10.03.19  
 Resolution: Accepted Disposition: use as is QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>56702</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
① 10/03/10	110	1 part's minimum flange thickness is .118 R.C: Program		Program is machining at the limit of tolerance .125 (-0.000/+ 0.030) Program mod has been done	J.A. 10/03/10			
② 10/03/10	110	1 part is .123 on flange in center of part R.C: Lack of Attention.		Forgot to raise 1 tool in program modification. Accepted by Eng. but blend out transition lines.	J.A. 10/03/10			

NOTE: Date & initial all entries



# Work Order ID 56702

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Page 2

Item ID: D3694-1

Accept

Revision ID:

Item Name: Mounting Plate

Start Date: 3/05/10 Start Qty: 5.00

Required Date: 3/12/10 Req'd Qty: 5.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

\*\*\*\*\*Mask all in surface as per Dwg

D3694\*\*\*\*\*START TIME:

8:15am OVEN TEMPERATURE: 9:45am FINISH

TIME:

320°F

MM= 10/03/15

10-3-15

=> 10/03/16

5 0

5 0

5 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56702**

March 4, 2010 12:43:35 PM



Page 3

Item ID: D3694-1

Accept

Revision ID:

Item Name: Mounting Plate

Start Date: 3/05/10 Start Qty: 5.00

Required Date: 3/12/10 Req'd Qty: 5.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

BK 10-3-16

5

4



QC

Memo

0.00

Quality Control

170

Identify as per dwg &amp; Stock Location: 285

0.00



Packaging

Memo

0.00

Packaging

10/4/18 5

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 10-3-18



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 4, 2010 12:40:38 PM

Page 25

Work Order ID: 56702

Parent Item: D3694-1

Parent Item Name: Mounting Plate

Comments: IPP Rev:A New Issue 09-01-13 JLM Verified By:DD

Start Date: 3/05/10

Required Date: 3/12/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X06.00 0		Purchased	No				f	12.4400	3.1516			



6061T6 BAR 1.00 X 6.00



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

12.44

110550

12.44

3.0000<sup>ft</sup> B.A 10/03/10

March 4, 2010 12:40:38 PM

Shop Packet Print

Page 25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

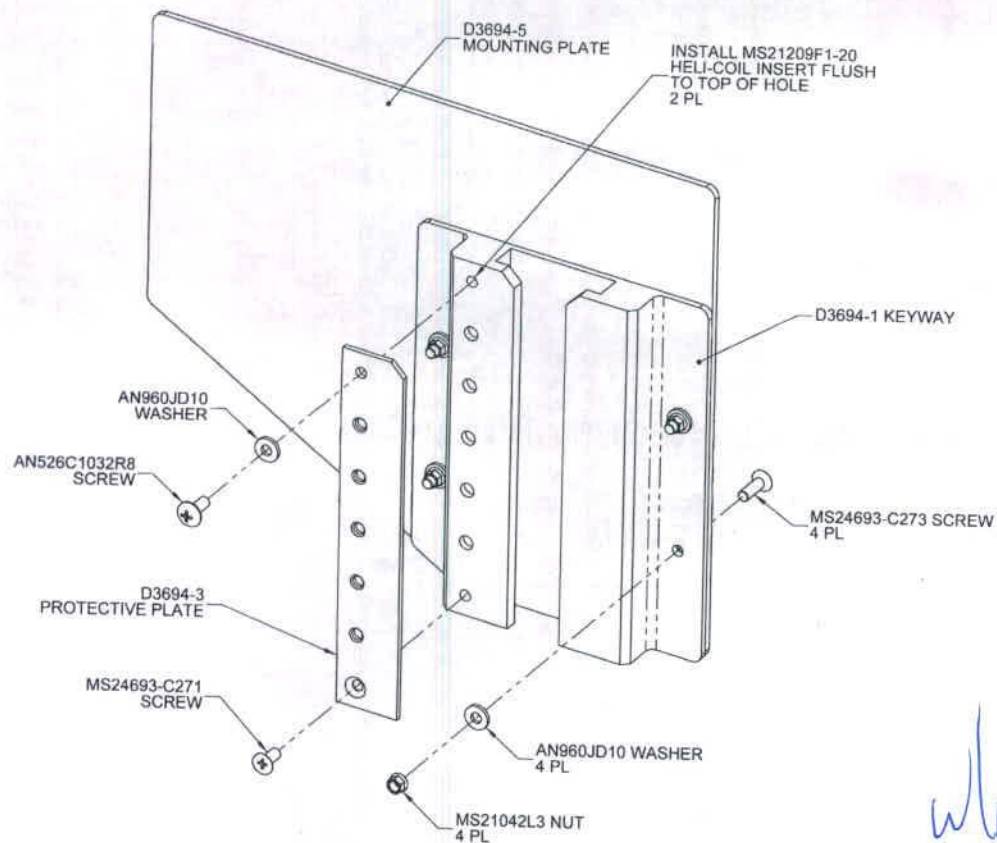
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3694-041 MOUNTING PLATE ASSY**

**D3694-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.70 lbs

ITEM	QTY	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

**RELEASED**  
09/02/05

C	REDESIGNED ITEM 11; REVISED ITEM 12- DIM @0.204 WAS @0.234 (ZN D6-3); ADDED ITEM 13; UPDATED BOM TO CURRENT STANDARDS (ZN D3-1); REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT.	MB	08.11.03
B	QTY 1 MS24693-C271 SCREW WAS QTY 2 (ZN D3-1); ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1, ZN C7-1); 1.18 WAS 1.15 (ZN C7-3); CSK WAS 2 PL (ZN D4-3); 0.810 WAS 0.785 (ZN C3-3); REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP.	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3694</b> TITLE <b>MOUNTING PLATE ASSY</b> REV. C SHEET 1 OF 4 SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

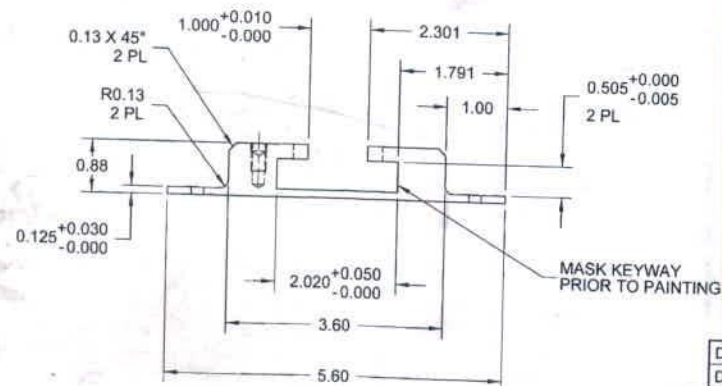
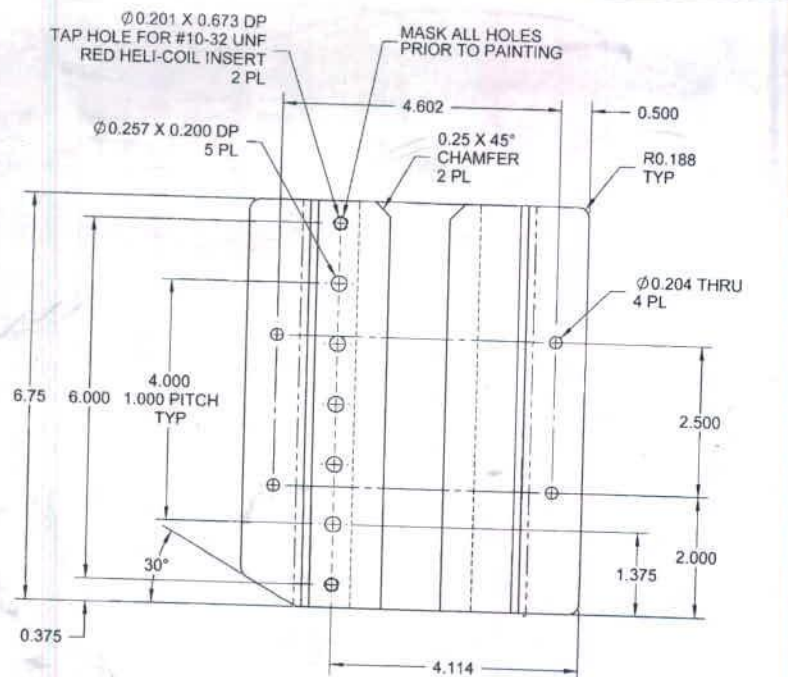
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3694-1 KEYWAY**

**D3694-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3694</b>	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING PLATE ASSY</b>	NTS
DATE	<b>08.11.03</b>	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED AND IS SUPPLIED IN THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATIONS TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
09/06/03

*W056702*



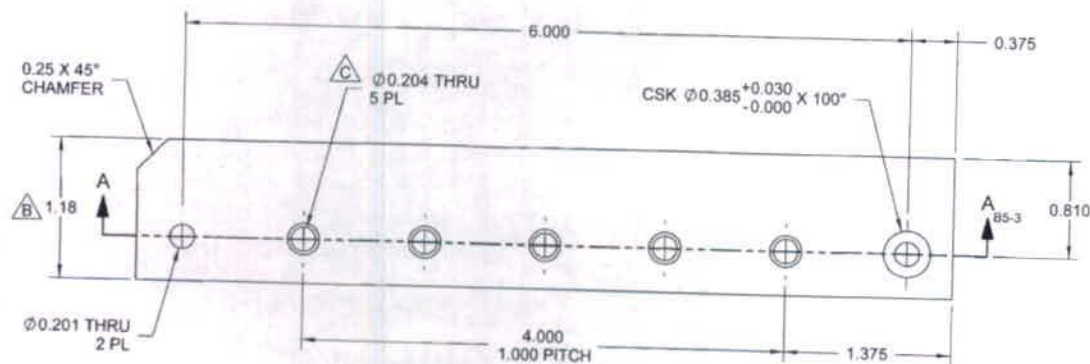
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

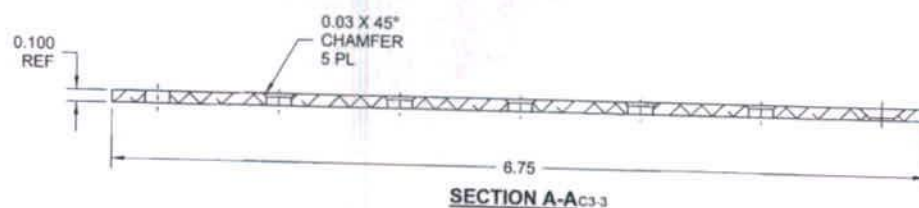
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3694-3 PROTECTIVE PLATE**



**SECTION A-A**

**D3694-3 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK),  
PER PER AMS 5513 OR AMS 5524  
REF. DART SPEC. M304S12GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
07/2/05

*W/O 56702*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

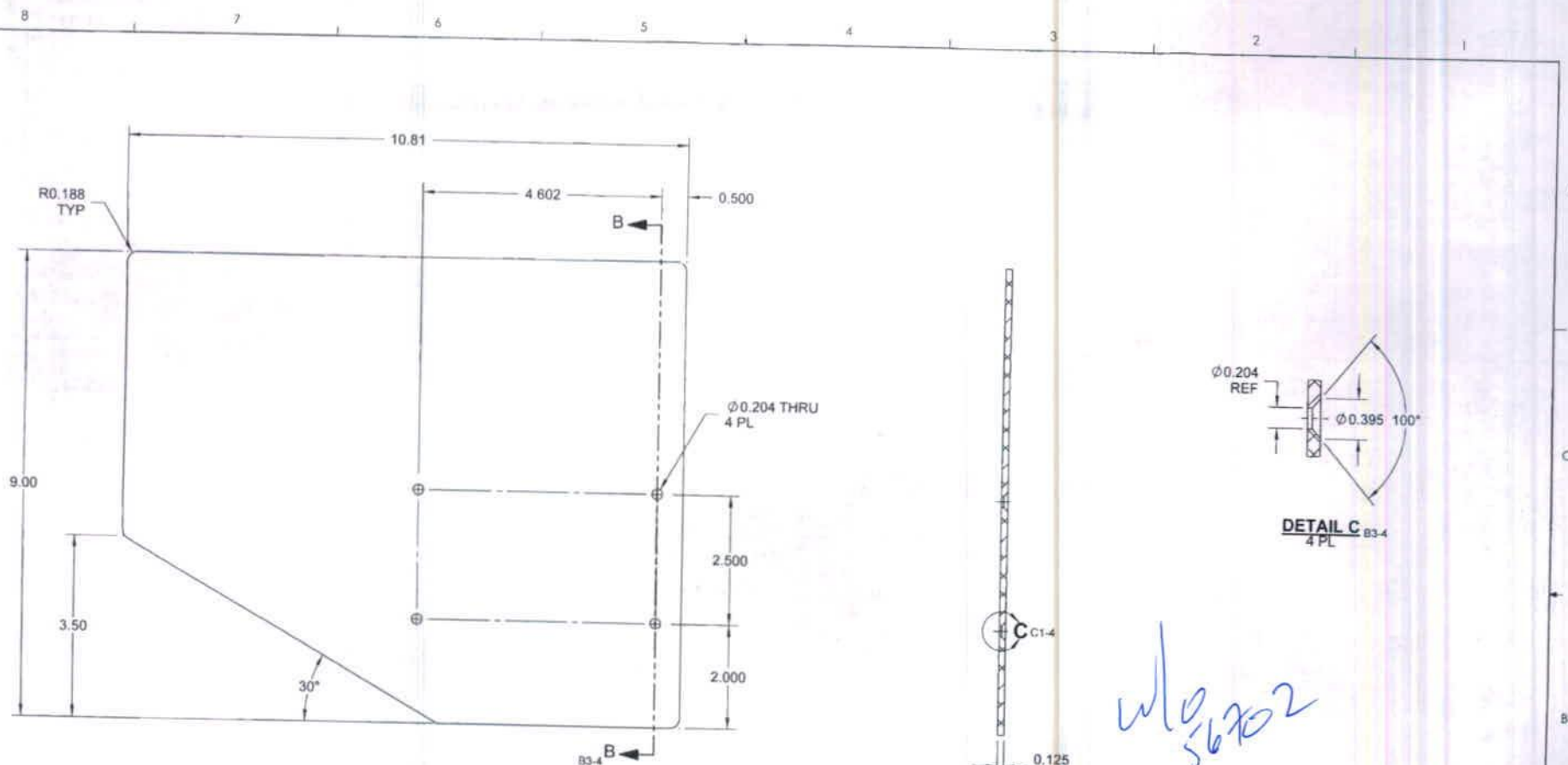
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

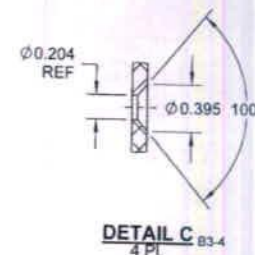
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3694-5 MOUNTING PLATE**



**SECTION B-B B5-4**

*W 56702*

**RELEASED**  
*09/05/05*

**D3694-5 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027  
REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3694</b>	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING PLATE ASSY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 86762
Description: Keyway		Part Number: D3694-1
Inspection Dwg: D3694	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201	+0.005/-0.001	Ø0.204	✓			
0.673 deep	+/-0.010	0.676	✓			
Ø0.257	+0.006/-0.001	Ø0.260	✓			
0.200 deep	+/-0.010	0.201	✓			
6.75	+/-0.030	6.749	✓			
6.000	+/-0.010	6.000	✓			
4.000	+/-0.010	4.000	✓			
1.000 pitch	+/-0.010	1.000	✓			
0.375	+/-0.010	0.379	✓			
4.114	+/-0.010	4.115	✓			
1.375	+/-0.010	1.378	✓			
2.000	+/-0.010	2.000	✓			
2.500	+/-0.010	2.501	✓			
Ø0.204	+0.005/-0.001	Ø0.206	✓			
0.500	+/-0.010	0.500	✓			
4.602	+/-0.010	4.601	✓			
1.000	+0.010/-0.000	1.001	✓			
0.13 x 45°	+/-0.030 x 0.5°	0.125 x 45°	✓			
R0.13	+/-0.030	R0.125	✓			
0.88	+/-0.030	0.882	✓			
0.125	+0.030/-0.000	0.131	✓			
5.60	+/-0.030	5.602	✓			See NCR for other parts.
3.60	+/-0.030	3.603	✓			
2.020	+0.050/-0.000	2.025	✓			
0.505	+0.000/-0.005	0.503	✓			
1.0	+/-0.030	1.001	✓			
1.791	+/-0.010	1.792	✓			
2.301	+/-0.010	2.300	✓			

Measured by: M.A
Date: 10/03/10

Audited by: MME
Date: 10/03/15

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	M



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries